

Date: Tuesday, 13/01/2009 4:07:30 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 44734
 Estimate Number : 13350
 P.O. Number :
 This Issue : 13/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 40367
 Written By :
 Checked & Approved By : mf 09-01-13
 Comment : Est Rev:A 08-05-29 new issue DD verified by:EC

Part Number : D35891
 Drawing Number : D3589 REV B PRELIM
 Project Number : N/A
 Drawing Revision : B PRELIM
 Material :
 Due Date : 15/01/2009 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



09.01.14 FOR ECW 09-502P

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0375W065	304 RD Tube .375 x .065W
Comment: Qty.: 1.6520 f(s)/Unit Total : 1.6520 f(s) 304 RD Tube .375 x .065W batch: <u>M 18993</u> <u>mf</u> 09/01/14		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- cut D3589-1 as per dwg D3589 2- chamfer both ends as per dwg D3589 3- deburr <u>mf</u> 09/01/14 <u>mf</u> 09/01/14 <u>mf</u> 09/01/14		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL <u>mf</u> 09/01/15 (12)		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <u>mf</u> 09/01/16 (1)		
5.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <u>mf</u> 09/02/17		

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.14 AUTH 11RELEASED mf DATE 09.02.17

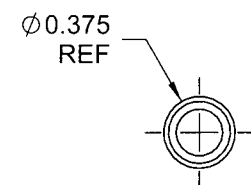
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

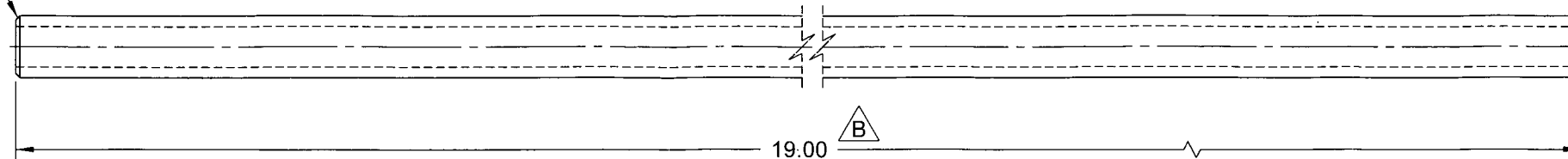
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

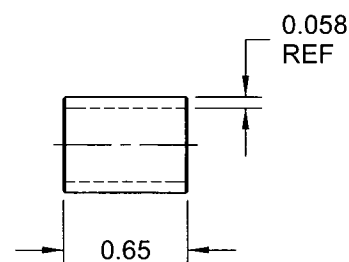
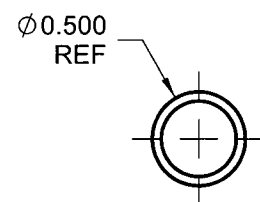


0.03 X 45°
CHAMFER
2 PL

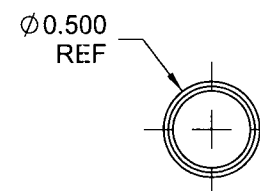


0.065
REF

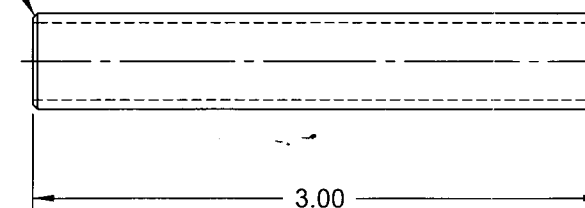
D3589-1 ARM



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

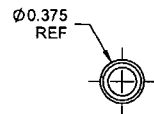
D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

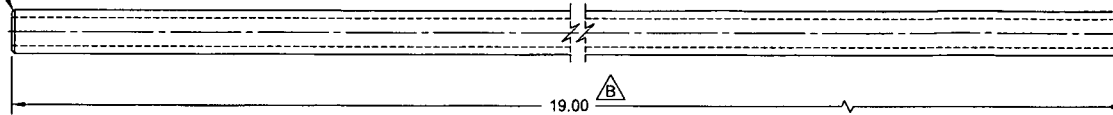
PRELIMINARY ISSUE

NO 9.01.14
POL ECU #09-502P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

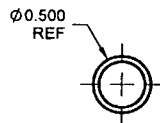


0.03 X 45°
CHAMFER
2 PL

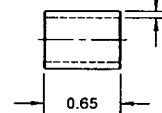


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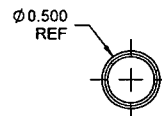
D3589-1 ARM



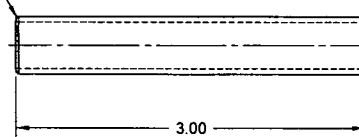
0.058
REF



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

44734

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RELEASED
09/02/05

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